

Date: Tuesday, 11/11/2008 11:28:24 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
<b>Job Number</b> :	43307	<b>Part Number</b> :	D29322UP
<b>Estimate Number</b> :	12930	<b>Drawing Number</b> :	D2932 REV C
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	11/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	C
<b>First Issue</b> :	11/11/2008	<b>Type</b> :	MACHINED PARTS
<b>Previous Run</b> :	42885	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	18/11/2008
<b>Checked &amp; Approved By</b> :	JLD 08.11.11		
<b>Comment</b> :	Est Rev:A New Issue 07-07-04 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0 x 6.25 X 7.88  
 Grain Along Long 7.88 Length  
 Batch No: B 34873

mrc 08/11/13

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 5-Deburr

mrc 08/11/13 J.L

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

mrc 08/11/13

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/11/2008 11:28:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 43307

Part Number: D29322UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 403

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43307	
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2932-2	
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.117	.116	.116	.115		
B	0.100	0.140		.118	.118	.118	.118		
C	0.100	0.140		.122	.125	.127	.127		
D	0.210	0.230		.220	.223	.223	.218		
E	1.245	1.255		1.250	1.248	1.249	1.249		
F	1.245	1.255		1.250	1.248	1.249	1.249		
G	2.495	2.505		2.500	2.498	2.500	2.500		
H	0.510	0.515		.510	.511	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.497	2.498	2.498		
K	0.257	0.262		.258	.260	.260	.260		
L	0.312	0.317		.314	.314	.315	.315		
M	0.235	0.240		.237	.236	.238	.237		
N	0.100	0.140		.110	.110	.112	.108		
O	0.540	0.560		.554	.551	.550	.550		
P	0.490	0.510		.497	.508	.509	.503		
Q	3.715	3.725		3.720	3.717	3.717	3.717		
R	2.470	2.510		2.492	2.493	2.492	2.493		
S	0.240	0.270		.257	.253	.252	.252		
T	0.100	0.180		.140	.141	.139	.140		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.134	1.137	1.134		
Y	1.565	1.585		1.570	1.575	1.578	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>IL</i>
Date: 08/11/13 08/11/12

Audited by: <i>SP</i>
Date: 08/11/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 43307
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2932-2
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	20	27	48		
A	0.100	0.140		.117	.126	.119	.115		
B	0.100	0.140		.118	.127	.120	.119		
C	0.100	0.140		.127	.127	.126	.127		
D	0.210	0.230		.218	.220	.219	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.499		
H	0.510	0.515		.511	.510	.511	.511		
I	1.572	1.582		1.576	1.575	1.575	1.575		
J	2.495	2.505		2.499	2.500	2.500	2.500		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.314	.315	.314	.315		
M	0.235	0.240		.238	.237	.236	.238		
N	0.100	0.140		.109	.108	.106	.108		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.499	.501	.500	.499		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.494	2.493	2.494		
S	0.240	0.270		.252	.253	.255	.253		
T	0.100	0.180		.138	.134	.128	.137		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.132	1.133	1.130	1.130		
Y	1.565	1.585		1.572	1.573	1.570	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>mm</i>
Date: 08/11/11

Audited by: <i>SP</i>
Date: 08/11/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43307
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2932-2
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

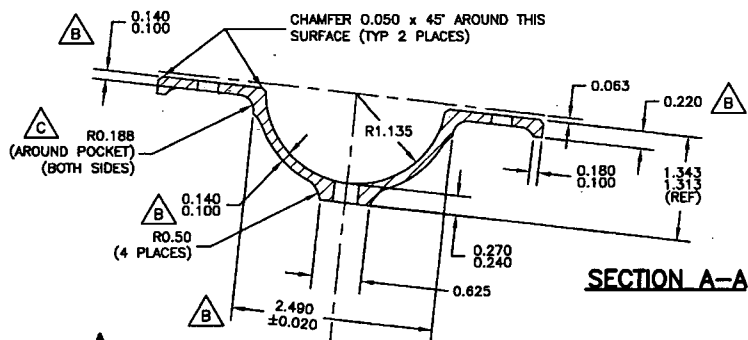
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	10	3	4	By	Date
A	0.100	0.140		.118	.119				
B	0.100	0.140		.118	.119				
C	0.100	0.140		.131	.131				
D	0.210	0.230		.218	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.575	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.260	.260				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.108	.108				
O	0.540	0.560		.549	.550				
P	0.490	0.510		.499	.500				
Q	3.715	3.725		3.717	3.717				
R	2.470	2.510		2.492	2.493				
S	0.240	0.270		.253	.254				
T	0.100	0.180		.134	.136				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.320	.320				
X	1.125	1.145		1.131	1.130				
Y	1.565	1.585		1.570	1.571				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

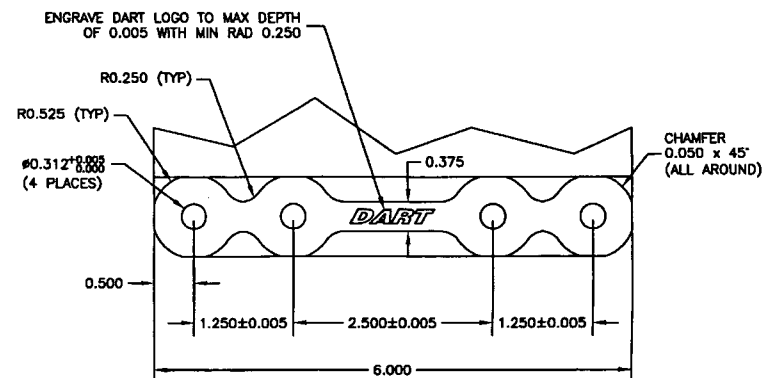
Measured by: <i>mmf</i>
Date: 02/11/14

Audited by: <i>SP</i>
Date: 02/11/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



SECTION A-A

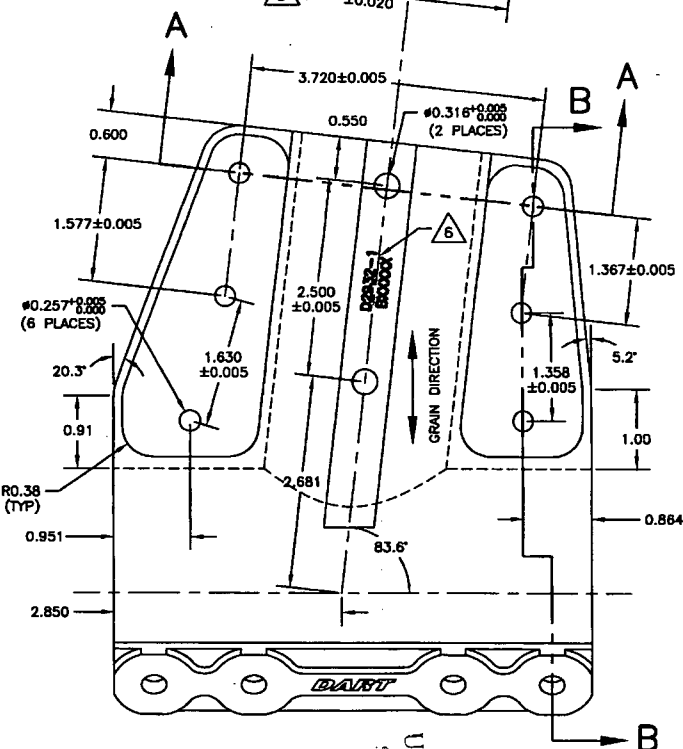


VIEW C-C

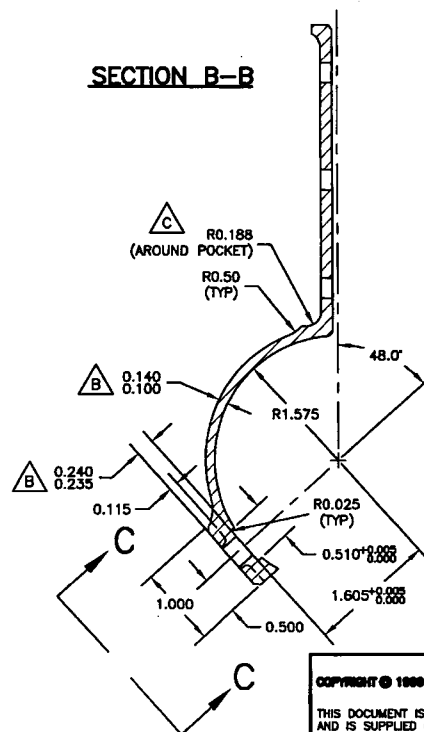
**D2932-1 LH SADDLE (SHOWN)**  
D2932-2 RH SADDLE (OPPOSITE)

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLVALE, VA
CHECKED	APPROVED	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE

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REV. C  
SHEET 1 OF 1

SCALE  
2:3

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07-02-12

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